

# Work Order ID 50475

July 10, 2009 2:23:24 PM



Page 1

Item ID: D3814-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge, Lower Airframe

Start Date: 7/13/09

Start Qty: 12.00



Cust Item ID:

Required Date: 7/13/09

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3814

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.75" " long

*ml 09/07/20*

*12 0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA780 Rev: *AA* & Dwg D3814 Rev: *A* 12-Deburr  
per dwg D3814 13-Finish tapping hole to final depth as per Dwg D3814

*ml 09/07/21*

*12 0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*LF 09/07/21*

*12 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50475

July 10, 2009 2:23:24 PM



Page 2

Item ID: D3814-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge, Lower Airframe

Start Date: 7/13/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/13/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

SA 09/07/23

12

0

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BR 09-07-27- (12)

Memo

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

\*\*\*MASK THREADED HOLE PRIOR TO POWDER COAT\*\*\* START

TIME: 1:00 COVEN TEMPERATURE:

320° FINISH TIME:

1:30

BR 09-07-27 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 50475



Page 3

July 10, 2009 2:23:24 PM

Item ID: D3814-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge, Lower Airframe

Start Date: 7/13/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/13/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09-07-28 V12 JF

170

Identify as per dwg & Stock Location: 136

0.00



Packaging

Memo

0.00

Packaging

9-7-28 2x JF

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

BS 28-07-06 09/07/28 JF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

July 10, 2009 2:23:24 PM

Work Order ID: 50475

Parent Item: D3814-3RevA

Parent Item Name: Hinge, Lower Airframe

Comments:



Unit of measure / 416

Start Date: 7/13/09

Required Date: 7/13/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6B2.000X03.50  
0

Purchased

No

110

f

7.6000

0.8320

4,992.



6061-T6 Bar 2.00 x 3.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

7.6

16391

7.6

16391

4.750' ml 08/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	50475
<b>Description:</b> Hinge, Lower Airframe		<b>Part Number:</b>	D3814-3
<b>Inspection Dwg:</b> D3814 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.30	+/-0.030	3.295	✓			
4.00	+/-0.030	3.994	✓			
0.75	+/-0.030	.742	✓			
0.13	+/-0.030	.119	✓			
R0.13	+/-0.030	.130	✓			
R0.250	+/-0.010	.250	✓			
1.50	+/-0.030	1.494	✓			
0.13	+/-0.030	.121	✓			
1.30	+/-0.030	1.302	✓			
0.20	+/-0.030	.200	✓			
0.50	+/-0.030	.500	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.50	+/-0.030	.500	✓			
1.00	+/-0.030	.994	✓			
1.81	+/-0.030	1.800	✓			
1.05	+/-0.030	1.050	✓			
0.21	+/-0.030	.205	✓			
1.00	+/-0.030	.997	✓			
0.05	+/-0.030	.048	✓			
0.75	+/-0.030	.747	✓			
0.31	+/-0.030	.306	✓			
R0.13	+/-0.030	.130	✓			
0.75	+/-0.030	.747	✓			
0.10 x 45°	+/-0.030 x 0.5°	.100	✓			
135°	0.5°	135°	✓			

<b>Measured by:</b>	SP	<b>Audited by:</b>	SA	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/07/21	<b>Date:</b>	09/07/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	AK

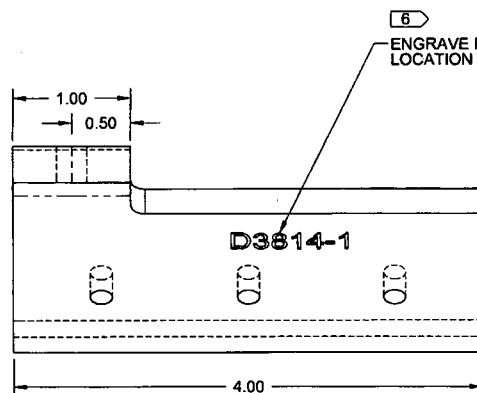
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

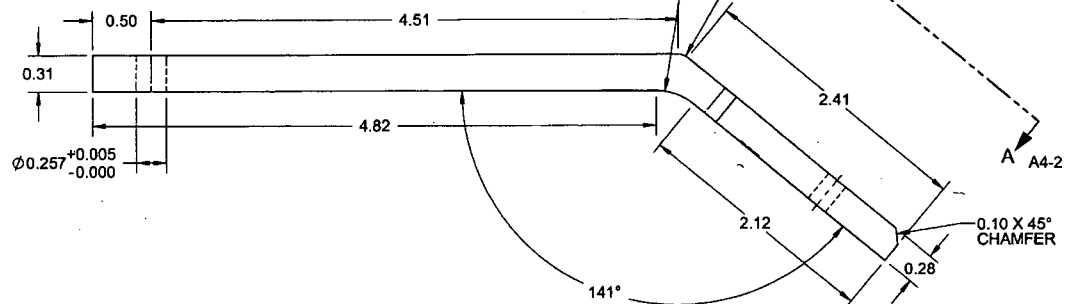
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**NOTE:** Date & initial all entries



6  
ENGRAVE P/N TO DEPTH OF 0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



*W/O 50475*

# D3814-1 HINGE, UPPER AIRFRAME

RELEASED  
09/01/13

## NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.36 lbs

A		NEW ISSUE		08.11.10	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO. D3814		REV. A	
MFG. APPR.		TITLE HINGE		SHEET 1 OF 3	
APPROVED				SCALE	
DE APPR.				NTS	
DATE	08.11.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

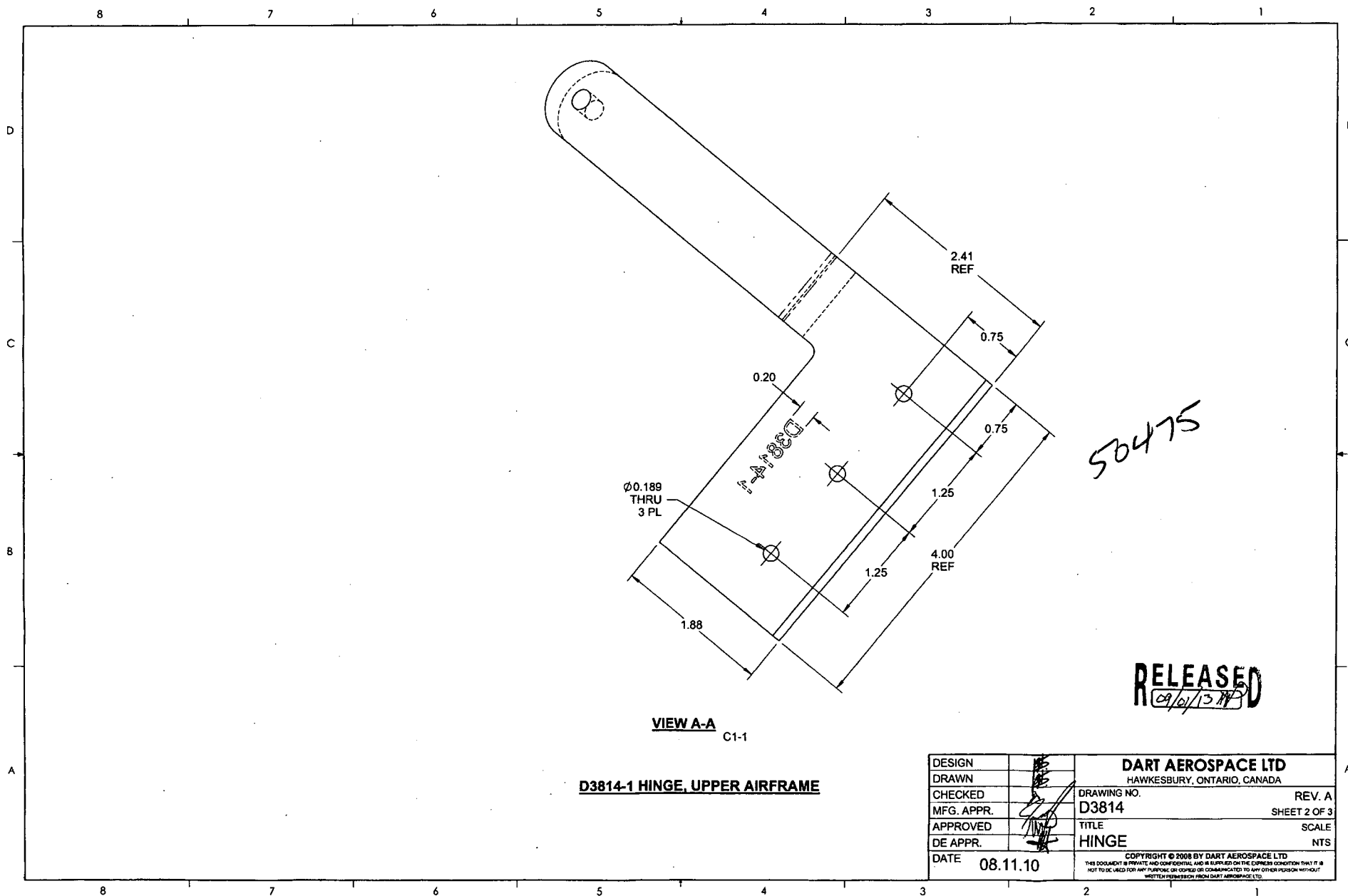
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



50475

RELEASED  
09/01/10

VIEW A-A  
C1-1

**D3814-1 HINGE, UPPER AIRFRAME**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3814	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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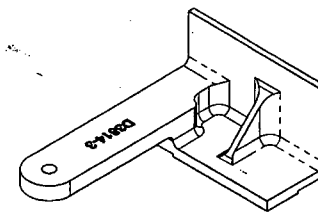
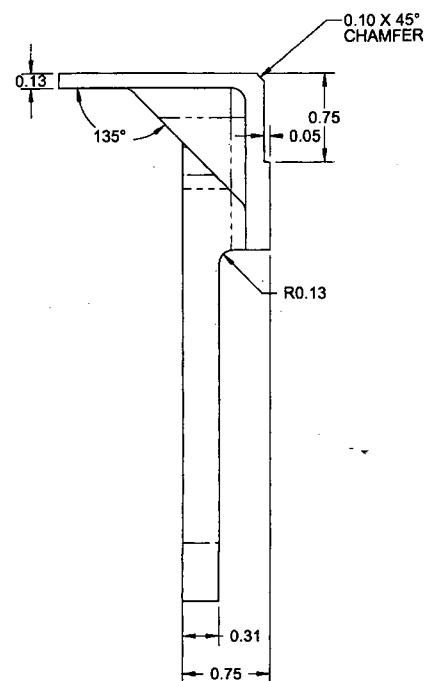
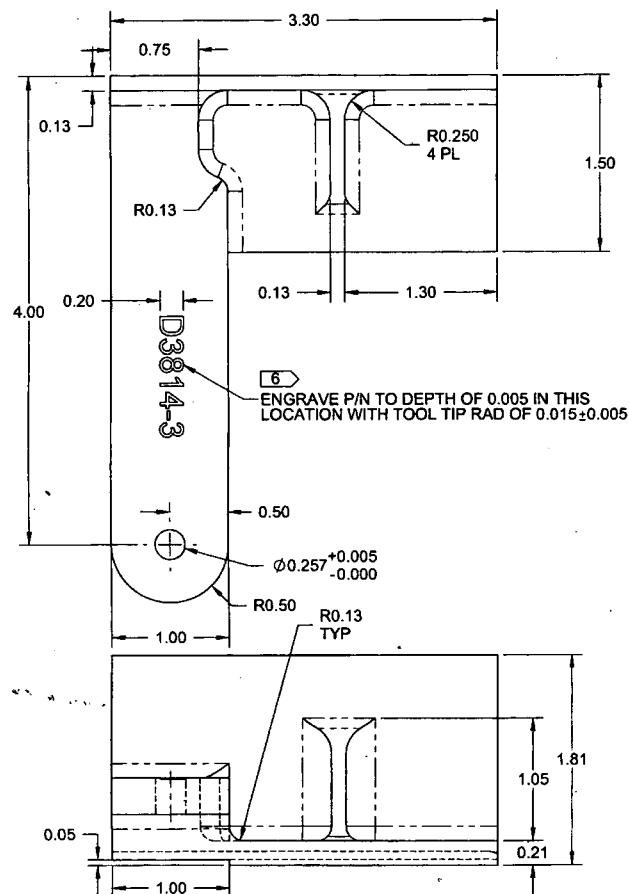
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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
50475

**D3814-3 HINGE, LOWER AIRFRAME**

**RELEASED**  
09/01/12

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.31 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3814</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>HINGE</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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